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005210

D205-633-011
Job Sheet 182130



Part No: D205-633-011

Job Qty: 2 ea

Part Name: Heli-Access-Step™ - High Gear, Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/17/18

Job Tracking No:

Due Date: 8/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 17 IPP Rev:F 02.07.11 Reformat; Removed D3010 RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Lead Time	Sign-off
					Setup hrs	Run Hrs			
90	Start up Operation	2 Ea	8/13/18	8/13/18	0.00	0.00	Start Up Stores/Pkg-1	6	AUG 28 2018
110	Packaging	2 pcs	8/13/18	8/13/18	0.00	0.00	Packaging1-2	3-89	SEP 13 2018
120	QC	2 pcs	8/13/18	8/13/18	0.00	0.00	QC4		SEP 13 2018
130	Packaging	2 pcs	8/13/18	8/13/18	0.00	0.00	Packaging3-1		SEP 13 2018
135	DC	2 pcs	8/13/18	8/13/18	0.00	0.00	DC		SEP 13 2018
140	QC21-FG	2 Ea	8/13/18	8/13/18	0.00	0.00	QC21		SEP 13 2018

Part Op 130 - Identify and pack for shipping as per PPP D205-633-011 Location:FG082
Descriptions: 135 - Photocopy bluefile & type labels per PPP205-633-011 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5094583
AN4-5A	Bolt	4 Ea (2 ea)	90-Start up Operation	5027725
AN4-6A	Bolt	4 Ea (2 ea)	90-Start up Operation	5084455
AN4-7A	Bolt	4 Ea (2 ea)	90-Start up Operation	5057520
AN5-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5050344
AN5-6A	Bolt	2 Ea (1 ea)	90-Start up Operation	5010742
D2021-101	Eyebolt	2 Ea (1 ea)	90-Start up Operation	5091964
D2022-101	Spacer	4 Ea (2 ea)	90-Start up Operation	5106656
D2022-103	Spacer 5109876x3	4 Ea (2 ea)	90-Start up Operation	5045072-X1
D2562-001	Strut 19.68"	2 Ea (1 ea)	90-Start up Operation	5092149X1
D2565-101	Strut 5109425x1	2 Ea (1 ea)	90-Start up Operation	5092137X1
D2565-103	Strut 5101427x1	2 Ea (1 ea)	90-Start up Operation	5092149X1
D2565-105	Strut 5109448x1	2 Ea (1 ea)	90-Start up Operation	5092320X1
D2565-107	Strut	2 Ea (1 ea)	90-Start up Operation	5092248
D2565-109	Strut	2 Ea (1 ea)	90-Start up Operation	5092435x1
D2565-111	Strut	2 Ea (1 ea)	90-Start up Operation	5092430
MS21042L4	Nut	16 Ea (8 ea)	90-Start up Operation	5084365
MS21042L5	Nut	4 Ea (2 ea)	90-Start up Operation	5083541
NAS1149D0463J	Washer	30 Ea (15 ea)	90-Start up Operation	5089299
NAS1149D0563J	Washer	8 Ea (4 ea)	90-Start up Operation	5093773
D2563	Step Weldment Assembly	2 Ea (1 ea)	110-Packaging	5103063

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Inspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
		QTY Effective : _____		MRB (QSI042) Approval																	
	violation	Disposition			Completed By																
					Lead hand / Supervisor Approval Verification																
					QC / QA Coordinator Approval																

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Container No: S109863

Part: D205-633-011
Job No: 182130
Serial No/Batch: S109863
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: TC STC SH96-57 Issue 5, FAA STC SR00592NY 03/08/01, FAA STC

ROOT CAUSE			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-14A	2	417	0
	AN4-5A	4	215	0
	AN4-6A	4	1,336	0
	AN4-7A	4	76	0
	AN5-14A	2	70	0
	AN5-6A	2	98	0
	D2021-101	2	28	0
	D2022-101	4	3	0
	D2022-103	4	1	0
	D2562-001	2	4	0
	D2565-101	2	2	0
	D2565-103	2	2	0
	D2565-105	2	2	0
	D2565-107	2	4	0
	D2565-109	2	2	0
	D2565-111	2	3	0
	MS21042L4	16	5,696	0
	MS21042L5	4	1,070	0
	NAS1149D0463J	30	9,729	0
	NAS1149D0563J	8	2,052	0
110-Packaging	D2563	2	4	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D205-633

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5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	3	3	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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